

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026390**Date Inspected:** 20-Sep-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2000**Contractor:** Watson Bowman Acme**Location:** Buffalo, NY**CWI Name:** John Miller**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hinge A Expansion Joint**Summary of Items Observed:**

On this date, Quality Assurance Inspector (QAI) Fred Edmondson was present at the Watson Bowman Acme Corporation (WBA) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

This (QA) Inspector met with Watson Bowman Acme Corporation Quality Control Manager (QCM) Gregory Ross, Quality Control Supervisor (QCS) John Miller and (KTA-Tator, American Welding Society Certified Welding Inspectors, (AWS CWI) Reno Davis and Claude Evans. AWS CWI Evans is assigned to the night shift.

This QA inspector observed certified welder Jason Gray #J stud welding ASTM A108 22 mm conical anchor studs (studs) to SEI 112667 CA1 and CA2 assemblies. The studs were welded in the flat (downhand) position using automatically timed stud welding guns per WBA approved WPS STUD-DA-01.

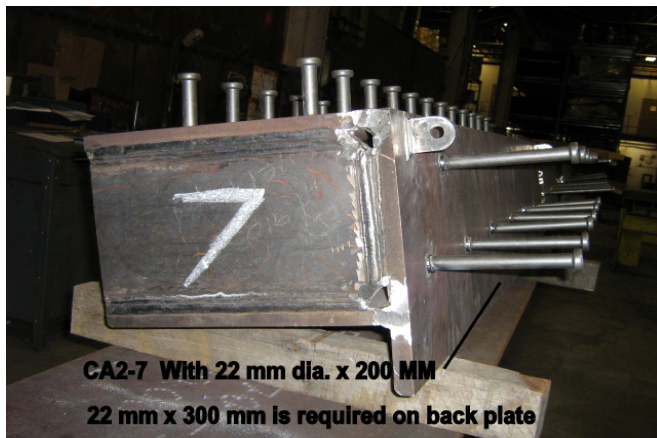
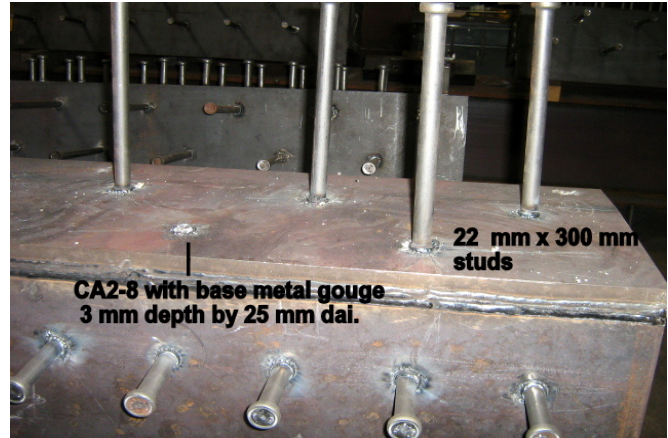
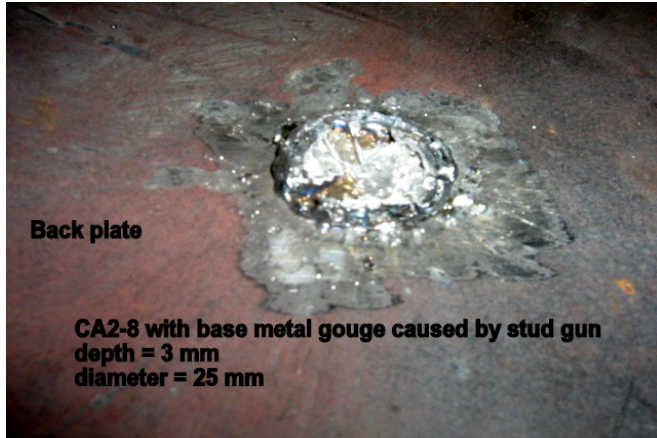
This QAI observed an area on the CA2-8 assembly (back plate) where base metal had been pulled out while stud welding was in-process. The dimensions are 3mm depth by 25mm diameter. QCS Miller stated that WBA will repair the gouged area in compliance with AWS D1.5 Section 7, Sub-section 7.7.5. The gouged area is going to be faired by grinding, filled by welding and then ground flush. QCS Miller stated the area may be magnetic particle tested (MT), after it is ground smooth and before welding a new stud (overlayed), although MT is not required by the AWS D1.5 code.

The CA2-7 back plate has 12 – 22mmX200mm studs welded to it instead of the required 22mmX300mm studs. The 200mm studs will be removed and replaced by the 300mm studs. The removal and replacement is to be in

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compliance with AWS D1.5 Section 7, Sub-section 7.7.5. QCS Miller stated areas where new stud weldment overlays previously welded locations may be magnetic particle tested prior to welding, although MT is not required by The AWS D1.5 code.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Edmondson, Fred

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer